Job Number **Estimate Number** P.O. Number This Issue Prsht Rev. First Issue **Previous Run** Written By Checked & Approved By

Monday, 1/8/2007 10:52:32 AM

NIA

: 29652

**Process Sheet** 

: CU-DAR001 Dart Helicopters Services Customer

: 30157 : 11167

Kim Johnston

:414: : 1/8/2007

S.O. No. : NA

Type

: SMALL /MED FAB

New issue KJ/JLM

**Part Number Drawing Number** 

**Drawing Name** 

: D32783 : D3278 REV B

: SPACER

: N/A Project Number : B **Drawing Revision** 

:NIA Material

: 1/30/2007 **Due Date** 

Each Qty: 40 Um:

**Additional Product** 

Job Number:

Comment



: Est . A04.04.19

Seq. #:

**Machine Or Operation:** 

Description:

1.0

MDELRINS0125X300

Black Delrin



Comment: Qty.:

0.0361 sf(s)/Unit Total:

1.4448 sf(s)

Black Delrin Use DT8685 Router Table.

Material: Black Delrin/UHMW 0.125" thick

(M-DELRIN-S0.125x30.0) Identify for D3278-3 Batch: M/0165

2.0

WATER JET

FLOW WATER JET



**Comment: FLOW WATER JET** 

1-Cut as per Dwg D3278

Dwg Rev: 3 Prog Rev: 13

2-Deburr if necessary

QC2 3.0

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK

4.0

QC8

Comment: SECOND CHECK



## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #: Fault Category: N	ICR: Ye	s No DQ	A: 🗲	Date:	7		
			ΟΔ.	N/C Class	٠. ا	Data			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	<del> </del>	Verification	Annroyal	Ammanual		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
Я										

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:52:32 AM Kim Johnston User: **Process Sheet Drawing Name: SPACER** Customer: CU-DAR001 Dart Helicopters Services Job Number: 30157 Part Number: D32783 Job Number: Description: Seq. #: **Machine Or Operation:** SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 5.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 X40 1-C'sink as per dwg D3278 2-Deburr INSPECT WORK TO CURRENT STEP 6.0 QC5 40 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_\_\_ FINAL INSPECTION/W/O RELEASE 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHA	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:					
			QA:	N/C Close	d:	_ Date: _					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	Corrective Action Section B			Verification	Ammayal	A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto		
			·							

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30157
Description: Spacer	Part Number:	D3278-3
Inspection Dwg: D3278 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
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	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	1.98	+/-0.030	1,99	. /		Vern	
	1.98	+/-0.030	1.99	1		Vern	
	1.480	+/-0.005	1.483			Vern	
	0.250	+/-0.010	0.255			Vern	
	1.480	+/-0.005	1.478	/		Vern	
	0.250	+/-0.010	0.255			Verm	
).	Ø0.098	+0.005/-0.000	\$0.100	1		Vern Vern Vern	
	- Ø9:188	70.010					
	1 6000	1/20-10-					
(	R0.12	+/-0.030	RO.12			R-G	
	0.125	+/-0.010	0,124			Vers	
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Measured by: SAD	Audited by:	Prototype Approval:	N/A
Date: 07/01/20	Date: 07/01/22	Date:	N/A

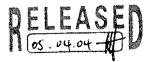
Γ	Rev	Date	Change	Revised by	Approved
Γ	Α	04.04.19	New Issue P/O D3278-041	KJ/JLM 1/A	
	В	06.03.09	Dwg Rev updated	KJ/JLM 🛠	411



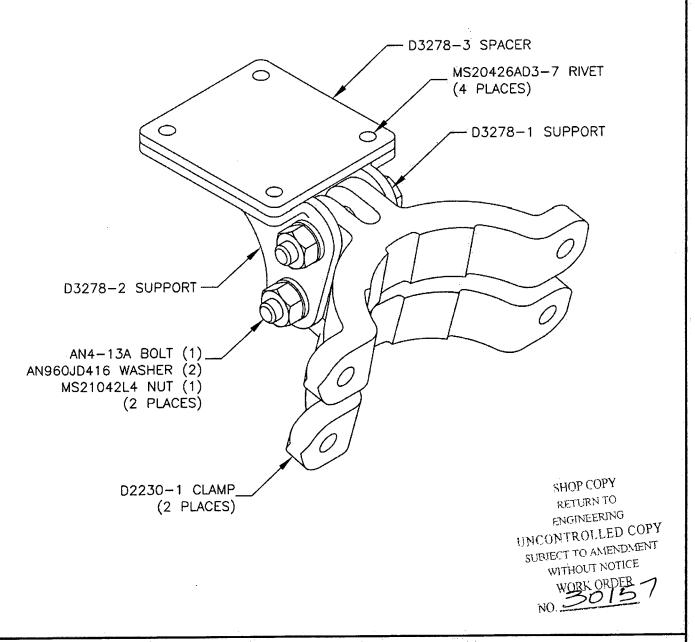
B 06.03.09 Dwg Rev updated



DESIG	CP	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECK	(ED #/	APPROVED	DRAWING NO.	REV. B
	at	- CHI	D3278 SHEET	1-OF 3
DATE		<u> </u>	TITLE	SCALE
05.0	3.31		SUPPORT ASSEMBLY	NTS
A·		04.03.03	NEW ISSUE	
В		05.03.31	CHANGE DIM/TOL TO ENSURE FIT	



## D3278-041 SUPPORT ASSEMBLY

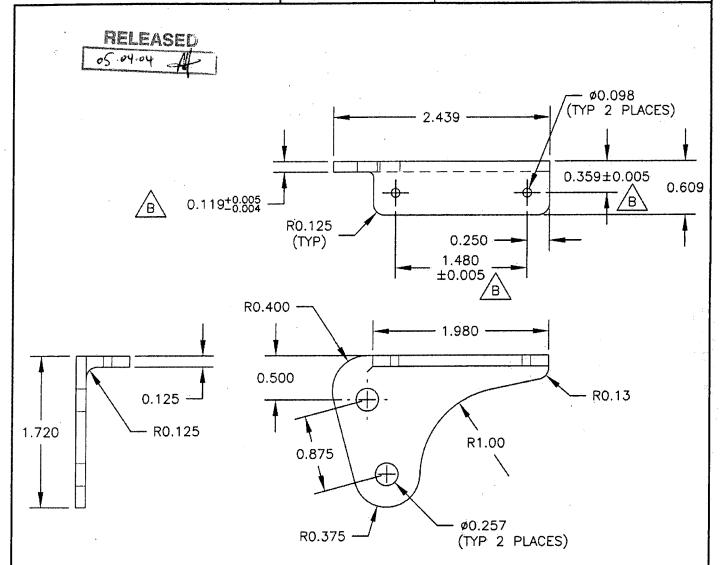


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DESIGN CP	DRAWN BY		RT AEROSPACE HAWKESBURY, ONTARIO, CANA	
CHECKED	APPROVED #	DRAWING NO. D3278		REV. B
DATE		TITLE		 SCALE
05.03.31		SUPPORT A	SSEMBLY	1:1



D3278-1 SUPPORT (SHOWN) D3278-2 SUPPORT (OPPOSITE)

1) MACHINE PER DWG FILE "D3278-1.SLDPRT"

SHOP COPY

2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/flux) TO (REF DART SPEC. M6061T6B OR M6061T6S) **ENGINEERING** 

3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 UNCONTROLLED CONY

4) BREAK ALL SHARP EDGES 0.005 TO 0.015

SUBJECT TO AMENDME WITHOUT NOTICE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 6) ALL DIMENSIONS ARE IN INCHES

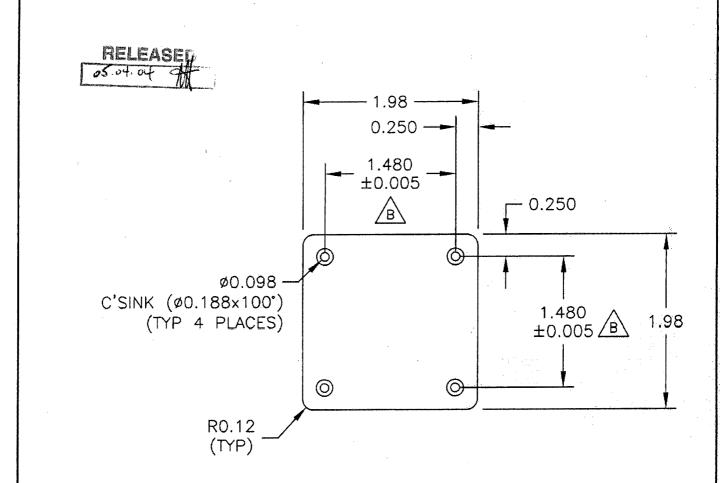
WORK ORDER

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	The Late Market Street Co.	<u> </u>		<u> </u>
DESIGN CP	ORAWN BY	DART AERO HAWKESBURY, C	SPACE LTD	
CHECKED	APPROVED #	DRAWING NO. D3278	SHEET	REV. B 3 OF 3
DATE		TITLE		SCALE
05.03.31		SUPPORT ASSEMBLY	<i>:</i>	1:1



**D3278-3 SPACER** 

SHOP COPY RETURN TO

1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR MADEERINGS UNCONTROLLED COPY 0.125 THICK SUBJECT TO AMENDMENT

2) BREAK ALL SHARP EDGES 0.005 TO 0.015

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

4) ALL DIMENSIONS ARE IN INCHES.

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